

8641



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT18700A-2
Job Sheet 184394



Part No: RBT18700A-2

Job Qty: 24 ea

Part Name: Bolt Modified



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/9/18

Job Tracking No:

Due Date: 10/15/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBT18700A Rev. A IPP Rev. A 18.08.17 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	24 Ea		10/15/18	0.00	0.00	Start Up Machining-3		
110	Mill Conv	24 pcs		10/15/18	0.00	2.40	Mill Conv 2		
120	QC	24 pcs		10/15/18	0.00	0.00	QC2 Machining-4		
130	QC	24 pcs		10/15/18	0.00	0.00	QC8 Machining-4		
150	Outsource	24 pcs		10/15/18	0.00	0.00	Outsource12		
160	Packaging	24 pcs		10/15/18	0.00	0.00	Packaging2		
170	QC	24 pcs		10/15/18	0.00	0.00	QC6		
180	Packaging	24 pcs		10/15/18	0.00	0.00	Packaging3-1		
190	QC21-SA	24 Ea		10/15/18	0.00	0.00	QC21		

Part Op 110 - - Machine as per DWG

Descriptions: 150 - -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
91251A422	Socket Head Cap Screw	24 Ea (1 ea)	90-Start up Operation	S070274 GA093

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	91251A422	24	250	0

Part Specifications



Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

not be found.

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Container No: S117074



Part: RBT18700A-2

Job No: 184394

Serial No/Batch: S117074

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 10/10/18

8 7 6 5 4 3 2 1

D

C

B

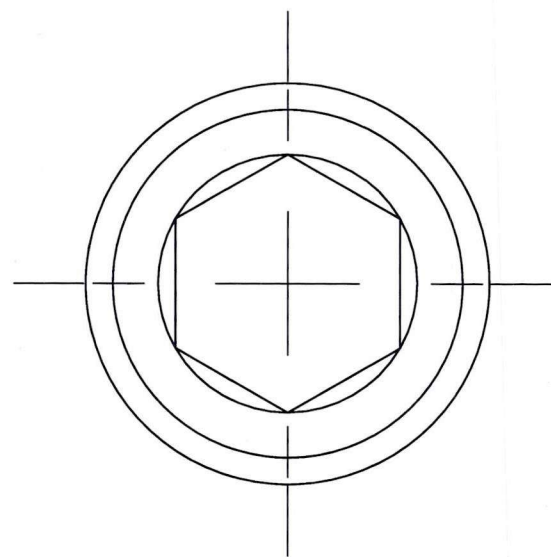
A

D

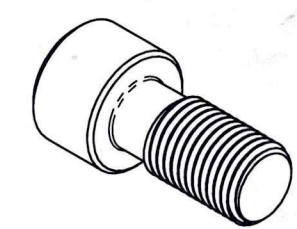
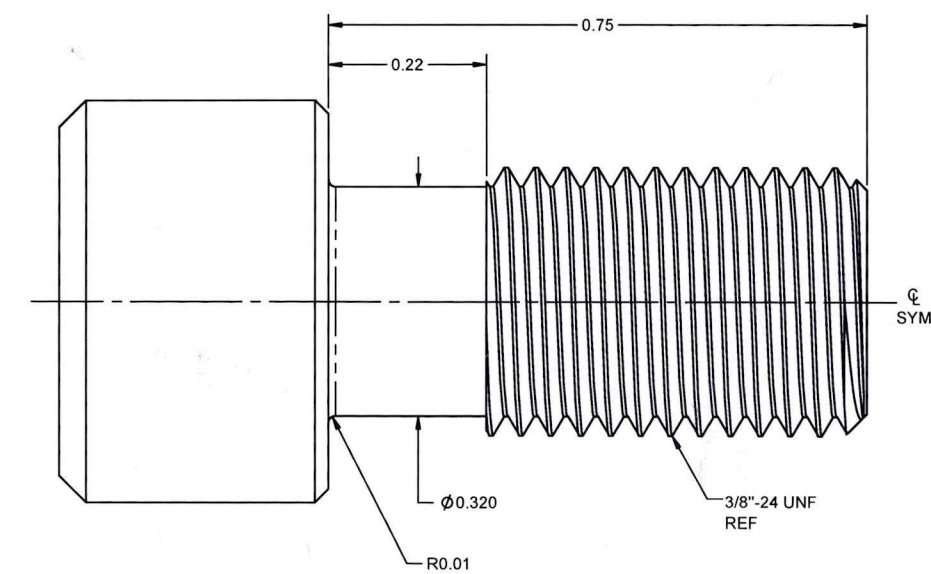
C

B

A



RBT18700A-2 BOLT MODIFIED



- NOTES:
- 1) MATERIAL: McMaster#91251A422 OR EQUIV
 - 2) HEAT TREAT: N/A
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RBT18700A	SHEET 3 OF 3
APPROVED	<i>M. Lee</i>	TITLE	SCALE
DATE 8/17/2018		ENGINE STAND C47 ADAPTER (2 PER SET)	NTS
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8 7 6 5 4 3 2 1

1145

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐		AGAINST DEPARTMENT/PROCESS				
Date : _____		Step #: _____		QTY Effective : _____		MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				
								Completed By
								Lead hand / Supervisor Approval Verification
								QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		FAULT CATEGORY		OTHER : _____				



Dart Aerospace Ltd.
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Tel (613) 632-5200

PURCHASE ORDER **PO041354**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO041354
PO Date: 10/15/18
Due Date: 10/19/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

REVISED

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

E-MAILED
OCT 18 2018

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	183537	RBE350A93-3300-20	Tail Rotor Hub Socket -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	10/19/18	16 pcs	0 pcs	16 pcs	\$3.79/pcs	\$60.64
			16 X OCT 23 2018								
2		RBD29826	4 Blade Tail Rotor Nut #369D21716-5 Torque Wrench Adapter -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	10/19/18	28 pcs	0 pcs	28 pcs	\$2.35/pcs	\$65.80
			28 X OCT 23 2018								
		184166									

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PURCHASE ORDER **PO041354**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	181885-A	RBEM622U3001101-7	Base Plate -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; -Certificate of Conformity is required	Firmed	-	10/19/18	7 pcs	0 pcs	7 pcs	\$6.75/pcs	\$47.25
							7X	OCT 23 2018			
4	184394	RBT18700A-2	Bolt Modified -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; -Certificate of Conformity is required	Firmed	-	10/19/18	24 pcs	0 pcs	24 pcs	\$0.95/pcs	\$22.80
							24X	OCT 23 2018			
Grand Total:											\$196.49



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Canada

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PURCHASE ORDER PO041354

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

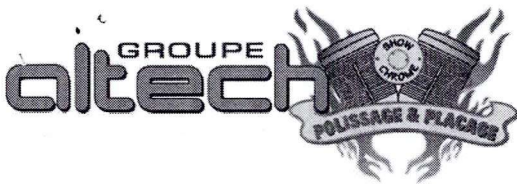
A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

A handwritten signature in dark ink, appearing to be "CL" or similar, located to the right of the list of procurement quality clauses.

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Certificat de Conformité / Certificate of Compliance

(013553-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

013553- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
23-Oct-2018		Jessie Boisvert		041354 ✓				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE350A93-3300-20 ✓ Rev.	RBE350A93-3300-20 01 -OXIDE BLACK [OXIDE BLACK] CLASS1 MIL-C-13924C	OXIDE-BLACK CH	16	16 ✓	0	0	0
2	RBD29826 ✓ Rev.	RBD29826 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	BLACK-OXIDE CH	28	28 ✓	0	0	0
3	RBEM622U3001101-7 ✓ Rev.	RBEM622U3001101-7 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1	OXIDE-BLACK CH	7	7 ✓	0	0	0
4	RBT18700A-2 ✓ Rev.	RBT18700A-2 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1	OXIDE-BLACK CH	24	24 ✓	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.